

Work Order ID 74852

Wednesday, October 12, 2011 9:49:08 AM

74852

Page 1

Item ID: D4095-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Assembly
 Start Date: 10/12/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 10/19/2011 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

PRELIMINARY ISSUE
 11.11.02

Approvals: Process Plan: MC Date: 11-10-12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4095	PB1 B 11.11.02 ECN #11-660	0.00							
100	FLOW WATER JET	0.00							
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D4095								
304 . 03	Dwg Rev: <u>PB1</u>								
	Prog Rev: <u>PB1</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

BIT 10-17

(10)

PB11-10-12

- inspect to PB1

Dwg only

5/10/13 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Dart Aerospace Ltd

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Page 4

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 Revision ID: Stop ***NS2***
 Item Name: Wearplate Assembly
 Start Date: 10/12/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 10/19/2011 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>11</u>	<u>11</u>	<u>11</u>	<u>27</u>
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							<u>11/10/27</u>
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>11/11/02</u>

POSITIVE RECALL

EFFECTIVE 11/10/27 AUTH u
 RELEASED 11/11/02 DATE 11.11.02
 ECN# 11-660

11-10-27
(10)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, October 12, 2011 9:49:07 AM

Page 1

Work Order ID: 74852

Parent Item: D4095-041

Parent Item Name: Wearplate Assembly

Start Date: 10/12/2011

Required Date: 10/19/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A nerw issue DD 10.04.26 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	46.2000	2.275	23.947368			

13-11-10-12

Location

Loc Qty

Loc Code

MAT020

46.2

118964

46.2

118217

118217

(10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 74852
Description: WEAR PLATE		Part Number: D4095-041
Inspection Dwg: D4095-1 Rev: PBI		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

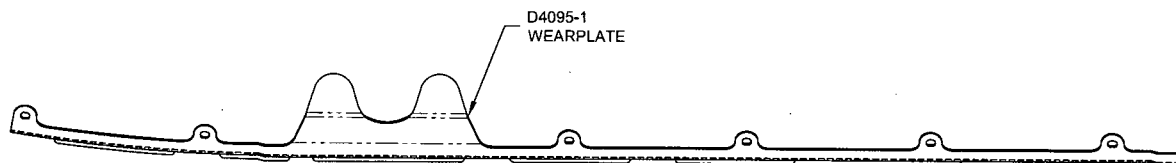
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .19	+.005 - .001	.190	✓		V RB2	
.300	± .010	.305	✓		V	
.300	± .010	.305	✓		V	
2.432	± .010	2.438	✓		V	
3.227	± .010	3.229	✓		V	
4.06	± .030	4.059	✓		V	
4.98	± .030	4.988	✓		V	
8.43	± .030	8.428	✓		PROW502	
11.50	± .030	11.50	✓		P	
11.472	± .010	11.472	✓		P	
6.32	± .030	6.32	✓		V	
3.500	± .010	3.50	✓		V	
24.750	± .010	24.750	✓		T RB1	
6.000	± .010	6.00	✓		T	
12.104	± .010	12.104	✓		T	
18.000	± .010	18.000	✓		T	
9.00	± .030	9.00	✓		T	
30.000	± .010	30.000	✓		T	
36.000	± .010	36.000	✓		T	
38.87	± .030	38.87	✓		T	
2.50	± .030	2.50	✓		T	
.063	± .010	.059	✓		V	

Measured by: RB	Audited by: S	Prototype Approval:
Date: 11-10-12	Date: 11/10/13	Date:
to PBI Daily		
Rev A	Date -	Change
		New Issue
Revised by KJ/JLM		Approved

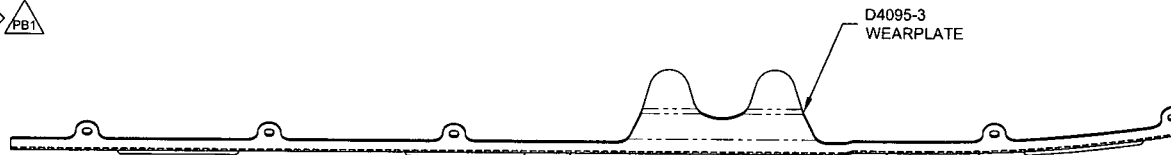
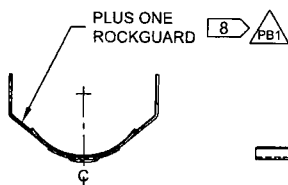
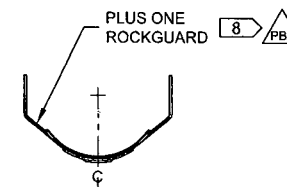
PRELIMINARY ISSUE

XDF 11.10.11

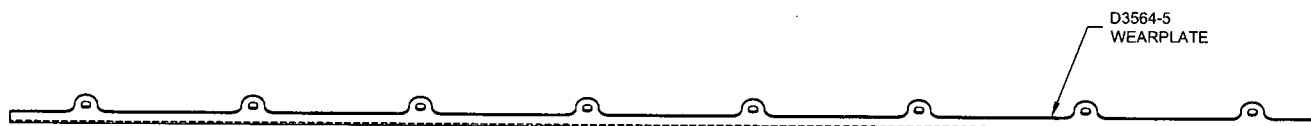
ITEM	QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
1	X			D4095-041	WEARPLATE ASSEMBLY
2		X		D4095-043	WEARPLATE ASSEMBLY
3			X	D4095-045	WEARPLATE ASSEMBLY
4			1	D3564-5	WEARPLATE
5	1			D4095-1	WEARPLATE
6		1		D4095-3	WEARPLATE
9	A/R	A/R	A/R	4715 (4714)	PLUS ONE ROCKGUARD BLACK (TAN)



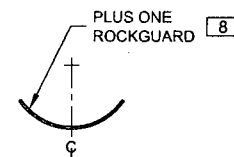
D4095-041 WEARPLATE ASSEMBLY



D4095-043 WEARPLATE ASSEMBLY



D4095-045 WEARPLATE ASSEMBLY



D4095-041/-043/-045 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-04X" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D4095-041 = 2.60 lbs; D4095-043 = 2.58 lbs
- 8) AFTER FINISH, COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK
- 9) PARTS ARE SYMMETRIC ABOUT

PB1	REVISED D4095-1/-1F/-3/-3F; 4715 PLUS ONE ROCKGUARD REPLACES D4096-1/-3; ADDED D4095-045 REVISED HARCOAT DESIGN; REVISED NOTE 8	XDF	11.10.06
A	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN	XDF		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.06		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4095
REV. PB1
SHEET 1 OF 5
TITLE WEARPLATE
SCALE NTS

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#74852

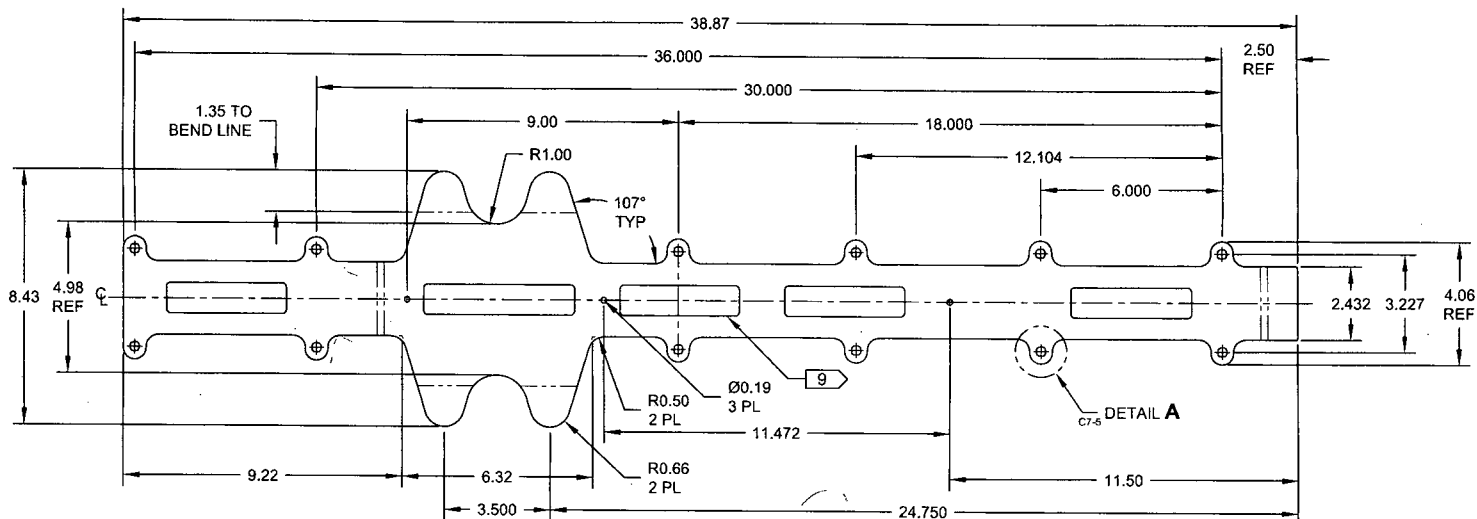
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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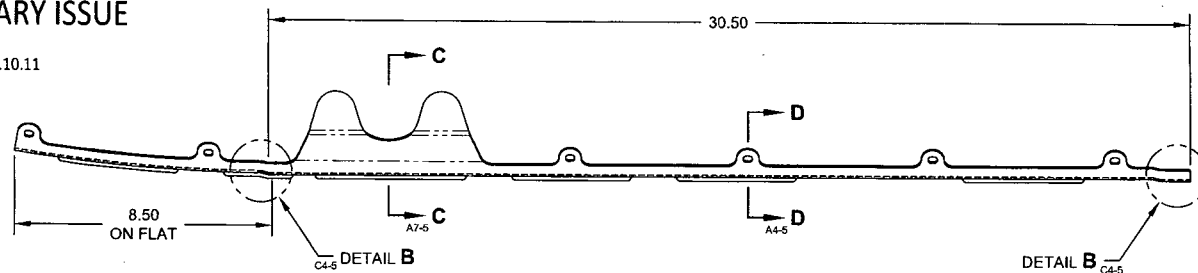
NOTE: Date & initial all entries



D4095-1F FLAT PATTERN 1

PRELIMINARY ISSUE

XDF 11.10.11



D4095-1 BENDING DETAIL
(MAKE FROM D4095-1F)

D4095-1/-1F/-3/-3F NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240
REF DART MATERIAL SPEC M304S16GA
- 2) ~~FINISH: POWDER COAT GREY SANDTEX (REF 4.3.6.6) PER DART QSI 005.4.3~~ N/A 11.10.21
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4095-1 = 2.18 lbs; D4095-3 = 2.16 lbs
- 8) WELDING: PER DART QSI 004
- 9) 2059B HARDCOAT WELD: WELD AFTER BENDING AS ILLUSTRATED PER DT8308,
0.13 THICK
- 10) PARTS ARE SYMMETRIC ABOUT C

DESIGN		DART AEROSPACE LTD	
DRAWN	XDF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PB1
MFG. APPR.		D4095	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	11.10.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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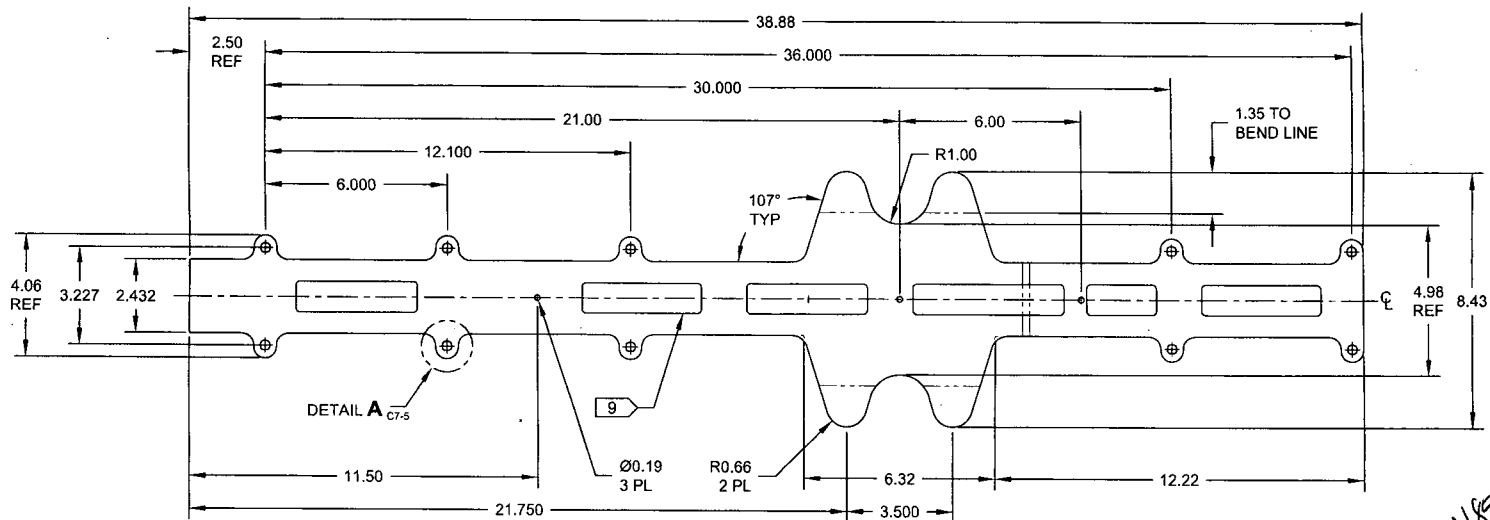
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

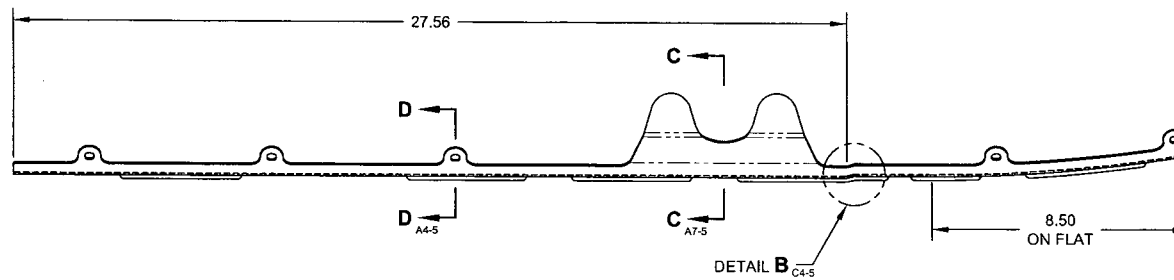
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NOTE: Date & initial all entries



D4095-3F FLAT PATTERN 1



D4095-3 BENDING DETAIL
(MAKE FROM D4095-3F)

PRELIMINARY ISSUE

XDF 11.10.11

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MFG. APPR.		D4095	SHEET 3 OF 5
APPROVED		TITLE	SCALE
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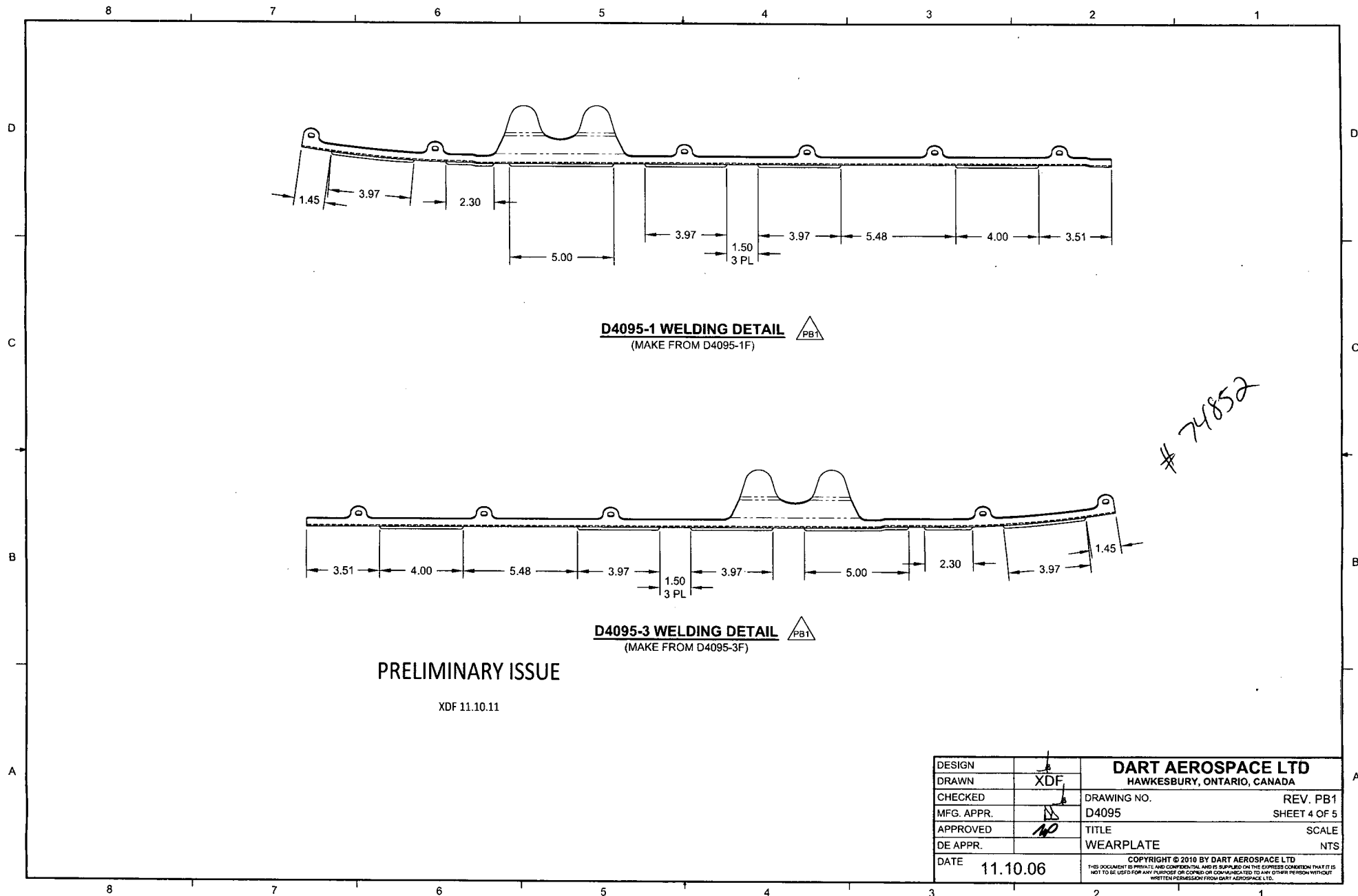
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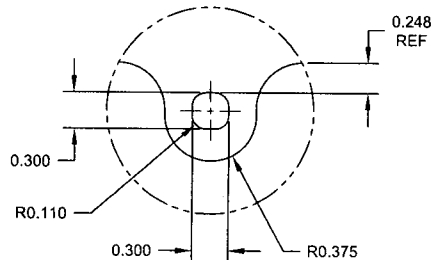
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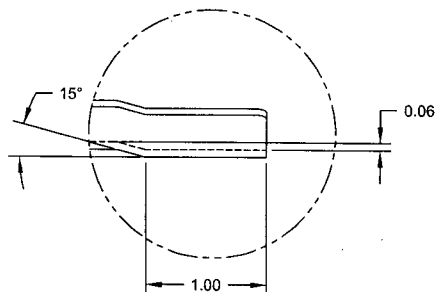
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DETAIL A: TAB DETAIL

SCALE 4X
C3-2
C6-3

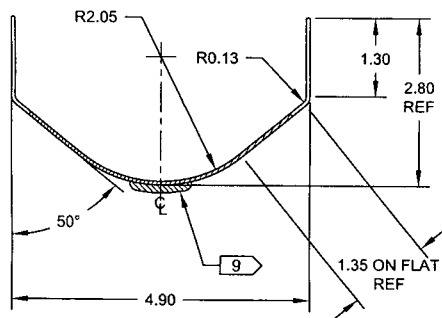


DETAIL B: JOGGLE DETAIL

SCALE 4X
B2-2
B6-2
B4-3
B7-3

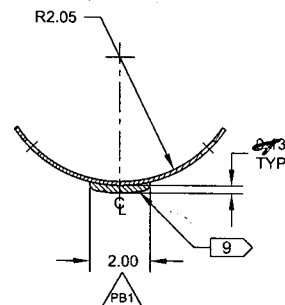
PRELIMINARY ISSUE

XDF 11.10.11



SECTION C-C

SCALE 2X
B5-2
B4-3



SECTION D-D

SCALE 2X

DESIGN		DART AEROSPACE LTD	
DRAWN	XDF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PB1
MFG. APPR.		D4095	SHEET 5 OF 5
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#74857

0.19 TO 0.25 11.10.19
051042

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W/O:		WORK ORDER CHANGES					
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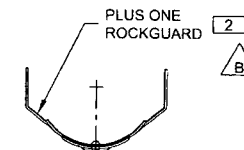
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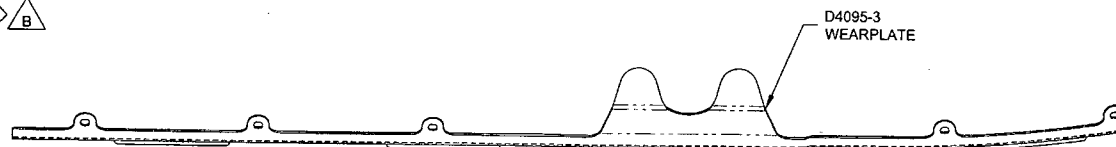
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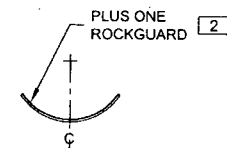
74852



74852



RELEASED
2011-10-31



D4095-041/-043/-045/-047/-049/-051 NOTES:

- 
- A triangle with the letter 'B' inside it.

74852